

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028571**Date Inspected:** 11-Oct-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job site**CWI Name:** Patrick Swain**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QAI) Rodney Patterson was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

The QAI observed ABF/JV welder Mike Jimenez #4671 performing Shielded Metal Arc Welding (SMAW) in the 4G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-1000-Repair. The repair was excavated and Magnetic Particle testing was performed on a previous shift at the following location,

13E-PP123-E2.8-BF3 (Face B)

Y=370

The weld and surrounding area was brought to a temperature by the use of a gas torch and maintained throughout the welding process. The repair was performed in accordance with the approval for repair document RWR201209-109 however; an error in the listed Welding Procedure Specification was noted in the repair document prior to repair, and a change to an applicable welding procedure was made in the field to suit. The QA Task leader was verbally notified of the change for further discussion with the Caltrans Structural Materials Representative (SMR) and ABF Management.

The QAI noted and periodically observed ABF/JV welder Rick Clayborn #2773 performing Carbon Arc Gouging (CAG) for the repair of the longitudinal deck drop-in weld designated as 13W-PP122,2 From Face B. The ABF/JV QC inspector Patrick Swain was observed performing magnetic particle testing (MT) in way of the repair

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excavations at the following locations,

13W-PP122.2(Face B)

Y=1060, Depth 8, Width 20mm, Length 70mm

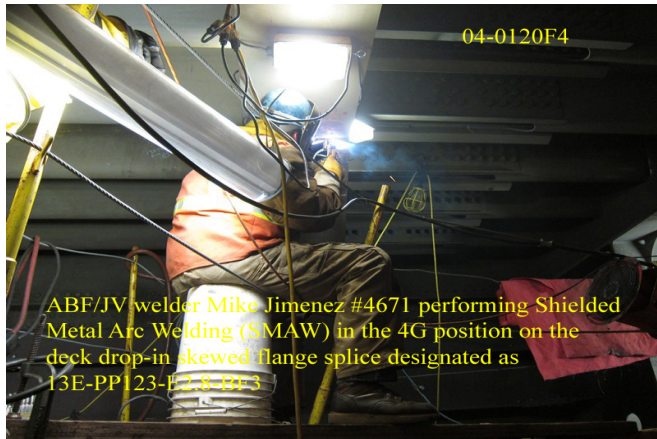
Y=1070, Depth 8, Width 20mm, Length 170mm

The ABF welder Rick Clayborn #2773 was observed later in the shift performing Shielded Metal Arc Welding (SMAW) in the 4G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1. 5-1004-Repair at the above mentioned location. The weld and surrounding area was brought to a temperature of 325°F by the use of induction heaters and maintained throughout the welding process. The repairs were then observed to be post heated at 450°F for one hour as required by the applicable repair document. Due to the first time repair at this location an approval for repair document was not required.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversations relevant to the work being performed.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Patterson,Rodney
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Quality Assurance Inspector

Reviewed By:	Reyes,Danny
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QA Reviewer
